

Work Order ID 52171

Thursday, September 17, 2009 10:42:41 AM



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Item ID: D3505-1	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: Web					
Start Date: 9/17/2009	Start Qty: 4.00		Cust Item ID:		
Required Date: 9/24/2009	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>RF MK</u>	Date: <u>09-9-17</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3505	Rev A								

100		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut to Lenght as per Dwg D3505 2-Drill Pilot Holes using DT8869 Drill Jig 3-Open pillots to 1.000" as per Dwg D3505 4-Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

web 09-09-28
09 09 28 (4)

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Item ID: D3505-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Web

Start Date: 9/17/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00



QC

Memo

DP
9-9-28

0.00

Quality Control

140 Identify as per dwg & Stock Location

0.00



Packaging

Memo

Skidule
cel

0.00

Packaging



Q MB 09-09-28

150 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/29

MF
09-09-29

Picklist Print

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Parent Item: D3505-1RevA



Parent Item Name: Web

Start Date: 9/17/2009

Required Date: 9/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2963-125RevA		Manufactured	No			120	Each	152.0000	4.0000			



105 I Beam Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

27775

8

28673

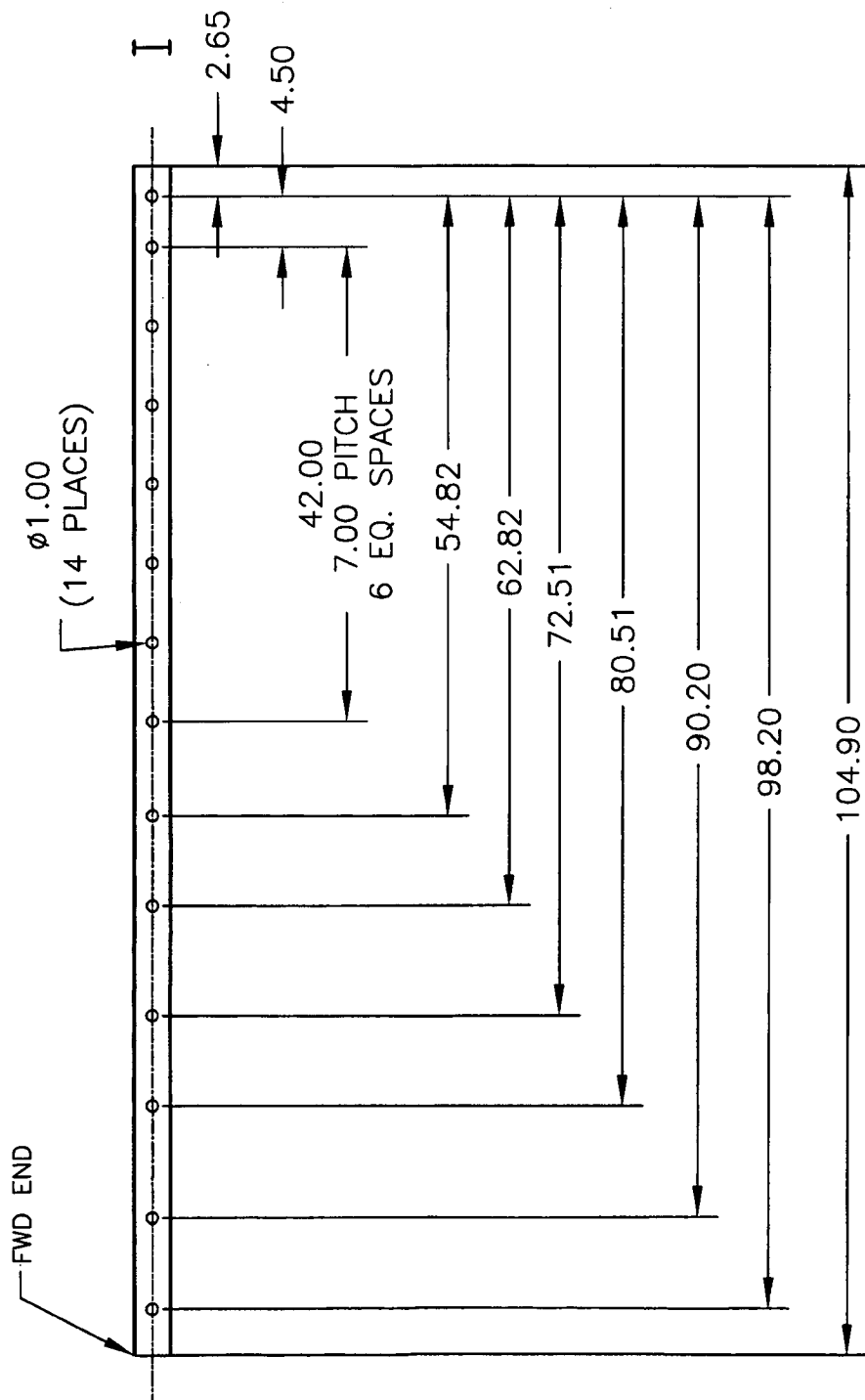
144

44

MR 09-09-28



DESIGN <i>PH</i>	DRAWN BY <i>PA</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3505	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE WEB	SCALE 1:15
A	06.04.21	NEW ISSUE	SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <u>52171</u>



D3505-1 WEB

RELEASED
06.10.02 #
REV ECN #851

D3505-1 WEB

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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